



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D350-636-012 Job Sheet 193164



Part No: D350-636-012

Job Qty: 1 pcs

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: SIOP

Due Date: 5/5/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG D2750-042 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per
dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD verified:EC
IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP Rev:P 10.06.22
revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R 13.08.27 PER ECN13-
594 DD VERF:JLM IPP REV:S 18.11.12 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	5/5/19		0.00	4.36	Skidtubes - 1		TF BE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	5/5/19		0.00	0.00	QC 10 - 10		DAS 24 9-89 APR 24 2019
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	5/5/19		0.00	0.00	QC 5 - 10		DAS MAY 01 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S172726



Part: D350-636-012

Job No: 193164

Serial No/Batch: S172726

Revision: H

Inspector:

Exp Date:

Instructions: FAA STC SR00645SE 18/10/17, TC STC SH99-7 Issue 2, EASA STC

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
140	Handfinish - 1-1 Chemical-B4B	1 pcs	5/5/19	0.00 0.91	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/05/02
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	1 pcs	5/5/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MLL
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160	Skidtubes - 2 - B4B	1 pcs	5/5/19	0.00 4.36	Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	

170 QC 10	1 pcs	5/5/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	PD 19-05-09
180 QC 5	1 pcs	5/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	5/5/19	0.00 0.91	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	5/5/19	0.00 0.69	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
205 Outsource	1 pcs	5/5/19		ATE003-VC	5
210 QC 14	1 pcs	5/5/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	5/5/19	0.00 0.91	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	

DAS
MAY 09 2019 68
9-89

D.R. 19/05/09

AS 19-5-9

NR

4114-5-13

19-5-14

DAS
15
9-89

240 QC 5	1 pcs	5/5/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	MAY 14 2019
				QC 5 - 9	DAS 68
				QC 5 - 50	9-89
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	5/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	5/5/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	

270 Packaging 3-1 - Stock - B4B

1
pcs

5/5/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS

58

9-89

MAY 14 2019

275 DC - 1 - B4B

1
pcs

5/5/19

0.00 0.00

DC - 1 - B4B

DC - 2 - B4B

DAS

21

9-89

MAY 14 2019

280 QC 21 - FG

1
pcs

5/5/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - FG - 53

DAS

21

9-89

MAY 14 2019

Part Op 110 - (Skidtubes) 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig
 Descriptions: DT8150 & DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes
 and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill
 pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of
 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI
 004 9- Grind welds flush as per Dwg D2750
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skidtubes) 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as
 per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3-
 Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per
 dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for
 welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291
 batch: 138989 exp. date: ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers
 D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod
 batch: 139011 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot
 face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of
 all scratches before sending to paint.
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

- 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
- 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349
BATCH: 5163577 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5173197
- 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
- 230 - (Assemble as per dwg) 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5174342 EXP
DATE: 14-12-8 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube
batch: 51133690 5-Coat all exposed fasteners with "LPS Procyon" batch: _____
- 240 - (QC5- Inspect part completeness to step on W/O)
- 250 - (Pick Kit)
- 260 - (QC4- 100% Inspect kits for completeness)
- 270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-012
- 275 - (Document Control) record fwd angle: _____ Photocopy blue file and type labels per PPP D350-636-012
CHG 008
- 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	5166246
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5150291
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5176881
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5162846
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5160920
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5107862 x2 5171591 x2
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5059805
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5156446
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5049457-2
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5149188
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5160325
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5163736
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5147789
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5163857
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5163290
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5174742
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5058407
D3791-1	Wearpad	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5141963
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5181091
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5149193
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5148669
NAS1149C0332R	Washer	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-2
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5093539
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5092499
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5106791
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5161572
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5176381
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5129315
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5171348
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5090421
D3532-1	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167203
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	10	0
	D2744	1	31	0
160-Skidtubes - 2 - B4B	D2739	1	11	0
	D2743	8	159	0
	D3490-1	4	30	0
	D3490-3	4	9	0
	ALS4-1032-225	38	1,284	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	1,310	0
	AN3C6A	4	218	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-4	1	2	0
	D3492-1	8	85	0
	D3492-3	8	179	0
	D3537-1	3	12	0
	D3631-1	8	213	0
	D3791-1	1	3	0
	D3793-1	1	7	0
	D3793-3	1	4	0
	D3793-5	1	15	0
	MS21043-6	4	160	0
	MS21083C8	1	336	0
	NAS1149C0332R	38	4,223	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
	NAS1611-010	8	375	0
	NAS1611-013	8	280	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	89	0
	D2741	1	67	0
	D3493-1	2	15	0
	D3532-1	2	69	0
	MS21083C8	2	336	0
	NAS1149D0863J	2	589	0
Part Specifications				
Specifications could not be found.				